Work Order I April-04-14 10:13:07				*115	5557*	200				Page 1	
Revision ID:	36-23 et Center			Accept	*N900	040	100)* s	etup Start		S1* S2*
Start Date: 4/04, Required Date: 4/04, Reference:			*6* *6*		Cust Item Customer:	ID:				10	. 7/
Approvals: Pro	cess Plan: MLJ	Date:	14-04-04	Tooling:	D	ate:	_	R	kun Start	*N	R1*
QC	•			SPC (Y/N):		ate:			Stop		R2*
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D3536	Rev A										
*100 *100* Waterjet FLOW CNC Waterjet 100 003	FLOW WATER JET Memo 1-Cut as Deburr		6 Dwg Rev:	0.00 0.00 A Prog Rev:	1 2-	1000		/8			Jm14-05-2
¹¹⁰ *11∩*	QC2- Inspect parts o	ff machine FAI/	FAIB	0.00				13	ō		Jm14-05-
QC Quality Control	Мето			0.00				10_			<u> </u>
¹²⁰ *1 <i>つ</i> ∩*	QC8- Inspect parts -	second check		0.00 DAS 27 9-59	1			13			
QC Quality Control	Мето			0.00	15						
			* • *								·*

DQA:			Date:							$^{\mathcal{L}}$ arda $^{\mathcal{L}}$				
						WORK ORDER NON	-CC	ONFO	RMANCE / UI	PDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
	٠			-		Rework	1	Skid-tube Crosstube			7	Water Jet	\neg	Engineering
Part I	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	┪	Quality
	•					Use-as-is			noforming	Finishing	┥	re/Packaging	╗	Other
NCR I	NCR No.				Suspected Unapproved					Supplier				
Root	Des				Desci	ription of work order update		nitial	Act	ion	Sign &		П	•
Cause	ı	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	,	QC Inspector
Design					·								T	
Doc/Data														
Equip/Tooling							ļ						ı	
Handling/Pre													ĺ	
Material												:		
Operator														
Offset/Setup														
Process							1						ı	
Supplier							1						- 1	
Training				<u> </u>									l	
Transport													1	
Unapproved					L				<u></u>					
							FA	ULT CAT	regory					
Landi		3			_	General	_	1 .		_	7	r		
	<u> </u>	Bending				Bend		4	Program	<u> </u>	Outside Dim	ŀ	\neg	Pressure/Forced
	L	Centre N	ot Concer	ntric		BOM/Route	_	Grain		<u> </u>	Over/Under			Set-up
		Cracks			<u> </u>	Broken/Damage/Defect	_	Hardwa			Part Incorred	· · · · · · · · · · · · · · · · · · ·		Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave	_	Burrs		4 ·	ion Incomplete/Ur	- -	Part Lost/Mi	· · · · · ·	_	Weld
1		Cuffs			<u> </u>	Contamination	_	4	tions Incomplete/l	Unclear	Part Moved			Wrong Stock Pulled
	_	Crushing				Countersink			gned/off center	_	Positioned V		_	
	_	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislabe		L	Power Loss/	Surge		Other
		Inspectio	•	Tube	<u> </u>	Drawing	\vdash	Misrea						
	<u> </u>	Marks/Cl			<u> </u>	Drill Holes	\vdash	Off-set						
		Turning S	-			Finish	Out of Calibration							
		Wave/Twist in Tube		}	Fit/Function		Out of	Sequence						

115557 _M		*115557*						
Center Start Qty: 6.00	*6* *6*	Accept	*N900040 Cust Item ID: Customer:	100*	Setup	Start Stop	*NS1* *NS2*	
ss Plan:	Date:	Tooling:	Date:		Run	Start	*NR1*	
	Date:	\perp SPC (Y/N):	Date:			Stop	*NR2*	
Operation Description Identify as per dwg & S Memo	tock Location: FP-6	Set Up/ Run Hours 0.00	Tool ID Tool #				Reject Insp. Number Stamp	
QC21- Final Inspection	- Work Order Release	0.00						
Мето		0.00			Wrz		1-05-06	
					#14°C)5.0 <u>/</u>	D	
	Center Start Qty: 6.00 Req'd Qty: 6.00 Ss Plan: Operation Description Identify as per dwg & S Memo QC21- Final Inspection	Center Start Qty: 6.00 *6* Req'd Qty: 6.00 *6* ss Plan: Date: Date: Operation Description Identify as per dwg & Stock Location: FP-6 Memo	Accept Center Start Qty: 6.00 *6* Req'd Qty: 6.00 *6* SS Plan: Date: Tooling: SPC (Y/N): Operation	Accept *N900040 Center Start Qty: 6.00 *6* Req'd Qty: 6.00 *6* Date: Tooling: Date: SPC (Y/N): Date: Operation Description Identify as per dwg & Stock Location: Pool of the property of t	Accept	Accept *N900040100* Setup Center Start Qty: 6.00 *6* Req'd Qty: 6.00 *6* Date: Date: SPC (Y/N): Date: Operation Description Identify as per dwg & Stock Location: Plan Memo OC21- Final Inspection - Work Order Release Memo Ocept Accept *N900040100* Cust Item ID: Customer: Run Date: Date: Date: Customer: Run Tooling: Date: Customer: Run Code Qty Qty Occidentify as per dwg & Stock Location: O.00 O.00 OC21- Final Inspection - Work Order Release O.00 OC21- Final Inspection - Work Order Release	Accept *N900040100* Setup Start Stop Start Qty: 6.00 *6* Req'd Qty: 6.00 *6* Date: Tooling: Date: Stop Date: SPC (Y/N): Date: Stop Operation Description Identify as per dwg & Stock Location: Plan Accept Reject Qty Qty QC21- Final Inspection - Work Order Release OQC21- Final Inspection - Work Order Release	

DQA:			Date:											
						WORK ORDER NON	-CC	ONFO	RMANCE / UI	PDATE			AEROSPACE	
QA Closed:			Date:							V	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
	•					Rework	1	Skid-tube Crosstube				Water Jet Engineerin		
Part N	lo.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	•				.	Use-as-is	1 1	Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	lo.	<u></u>				Suspected Unapproved]		Large Fab	Composite		Supplier		
Root	ł				Desc	ription of work order update	ı	Initial	Act		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector	
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre	\dashv													
Material														
Operator														
Offset/Setup	\dashv													
Process	Н													
Supplier	Н						l							
Training														
Transport Unapproved	Н													
Ollapproved			<u> </u>	I	1		FΔI	LILT CAT	L TEGORY		<u> </u>	1		
Landi	ng (iear				General		<u> </u>						
	_	Bending				Bend]Folio/F	Program	Γ	Outside Dim	ensions	Pressure/Forced	
		Centre N	ot Concer	ntric		BOM/Route		Grain	J	ļ	Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ci J	Temperature/Cure	
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	issing	Weld	
\		Cuffs				Contamination		-i	tions Incomplete/U		Part Moved		Wrong Stock Pulled	
		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong _	<u> </u>	
		Heat Trea	at			Cut Too Short		Mislabe	eled	Γ	Power Loss/	Surge	Other	
,		Inspectio	n Strip in	Tube		Drawing		Misrea	d	_			***************************************	
,		Marks/Cl	natter			Drill Holes		Off-set	v .	***				
		Turning S	equence			Finish		Out of	Calibṛation 🦈 🧘	The state of the s				
1		Wave/Twist in Tube			Fit/Function		Out of Sequence							

JM14-05-2

April-04-14 10:13:07 AM

Work Order ID: 115557

115557

Parent Item:

D3536-23

D3536-23

Parent Item Name: Gasket Center

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 6.00

**

8.91

Required Qty: 6.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	1,048.300	1.3365	8.91			

MNF060S 063

Locat	ion	Loc Oty	Loc Code	
MAT	52	1048.3		
	M126546	27.1		
	M128266	221.2		198366
	M128339	800		

DQA:			Date:				DART							
QA Closed:			Date:			WORK ORDER NON	-CC	ONFOI	RMANCE / UP		ork Order up	date only	\neg	AEROSPACE
					•	DISPOSITION					PARTMENT			
Work Orde	er: _						. 1			AGAINST DE	.r Alvi (VILIVI) -	rnocess .		
						Rework		Skid-tube Crosstube			Water Jet Engineerii			Engineering
Part N	lo.					Scrap		l	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	_	Other
NCR N	NCR No.			_	Suspected Unapproved	Suspected Unapproved Large Fab Composite Supplier								
Root	Т				Desci	ription of work order update		nitial	Actio	on	Sign &	2	T	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	a 📗	QC Inspector
Design														
Doc/Data					i									
Equip/Tooling									-					
Handling/Pre							ļ							
Material							l							-
Operator														
Offset/Setup														
Process														
Supplier														
Training									ļ				-	
Transport														
Unapproved										****		!		
						<u> </u>	FA	ULT CA	TEGORY					
Landi	ng G	ear				General	_	1		_	7	1		
		Bending				Bend		•	Program		Outside Dim		_	Pressure/Forced
		Centre No	ot Concer	ntric	L	BOM/Route	<u> </u>	Grain		_	Over/Under	tolerance	\vdash	Set-up
		Cracks				Broken/Damage/Defect		Hardwa		<u></u>	Part Incorred		$\boldsymbol{\vdash}$	Temperature/Cure
	Crimp/Kink/Ripple/Wave			Burrs	L	4	ion Incomplete/Und	· —	Part Lost/Mi	ssing	\vdash	Weld		
	-	Cuffs				Contamination		4	tions Incomplete/U	nclear	Part Moved		ٰلـــا	Wrong Stock Pulled
	-	Crushing				Countersink		-	gned/off center		Positioned V	-		
	-	Heat Trea				Cut Too Short		Mislabe			Power Loss/	Surge		Other
	\vdash	Inspectio		Tube		Drawing.		Misrea						
1	Ш	Marks/Ch	natter			Drill Holes		Off-set						
	-	Turning S	· -			Finish			Calibration	•		···		
l		Wave/Twist in Tube		Fit/Function		Out of	Sequence	•						

DART AEROSPACE LTD	Work Order:	115557
Description: Gasket	Part Number:	D3536-23
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

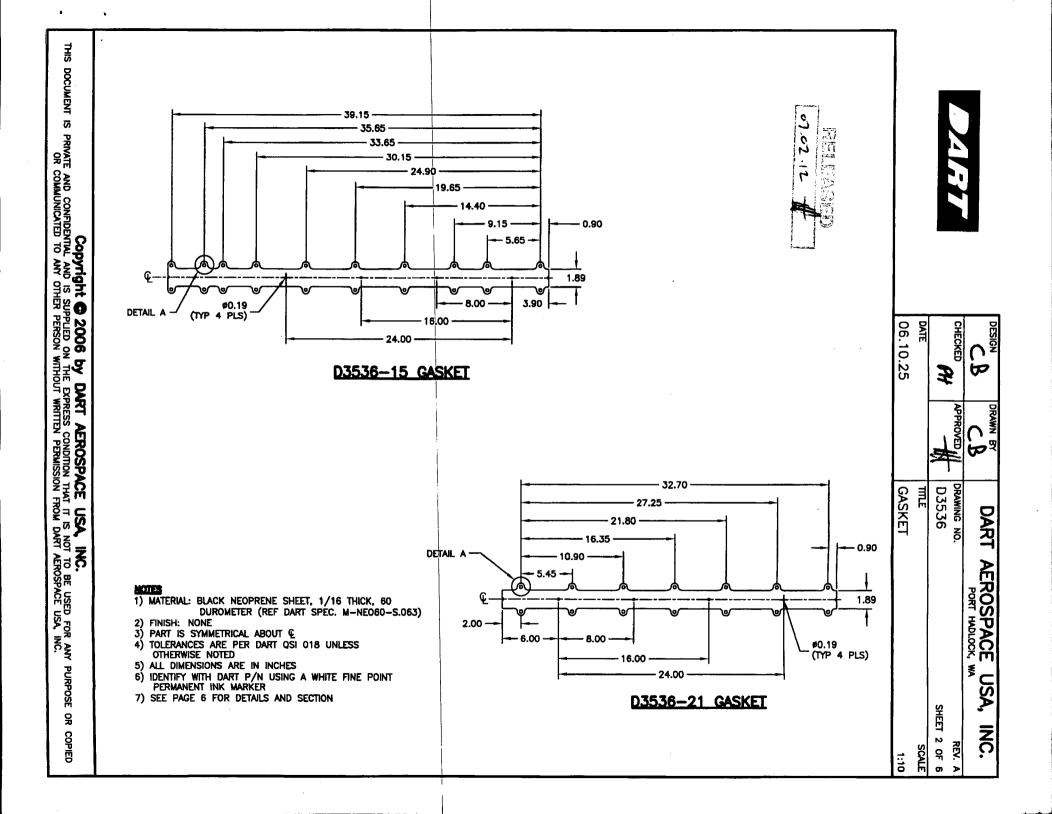
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	_			JLn07
48.20	+/-0.030	48.30	_		T	
44.70	+/-0.030	44.70"			+	
39.31	+/-0.030	39.31	_		T	
33.92	+/-0.030	33.92	_		1	
28.53	+/-0.030	28.534	_		T	
23.14	+/-0.030	23.14	_		7	
17.75	+/-0.030	17.25"	_		4	
14.25	+/-0.030	14-25			7	
9.50	+/-0.030	d.20,	-		ν	JAM 08
4.75	+/-0.030	21.75			V	Jan 08
8.00	+/-0.030	8.00	_		ν	
16.00	+/-0.030	16-004			7	
24.00	+/-0.030	24-00	-		7	
32.00	+/-0.030	3∂:∞"			T	
39.00	+/-0.030	39-000	_		T	
48.00	+/-0.030	48.00"			T	
0.30	+/-0.030	O. 38 ⁴	-		ν	
0.30	+/-0.030	0.30			ν	
1.89	+/-0.030	1.89"			V	
Ø0.19	+0.005/-0.001	0.19"			√	

Measured by: JM Audited by: 27 Prototype Approval: N/A

Date: 1405-2 Date: 145/5 Date: N/A

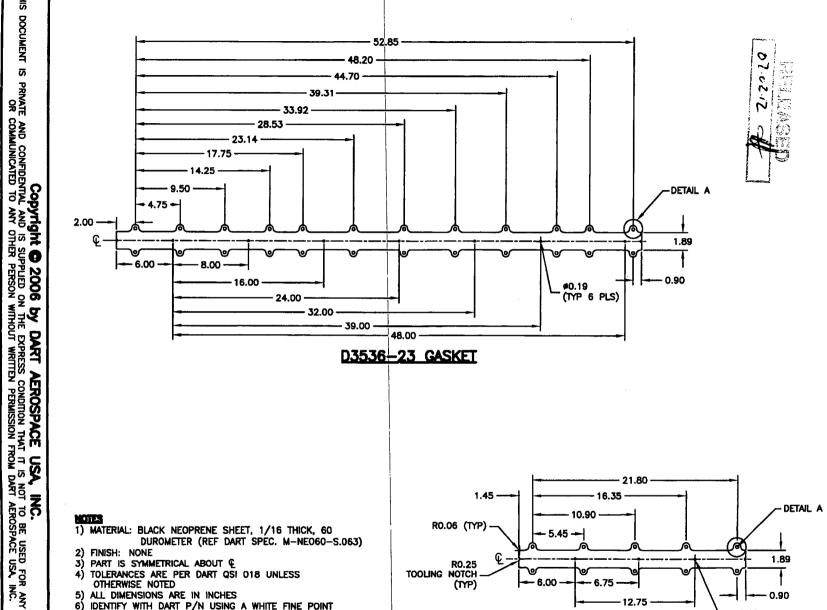
Rev	Date	Change	Revised by	Approx/ed
Α	07.03.14	New Issue	KJ/JLM CK	
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PURPOSE

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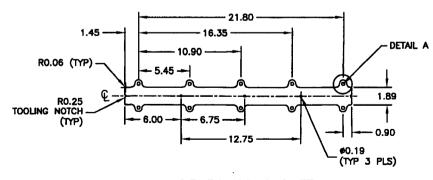
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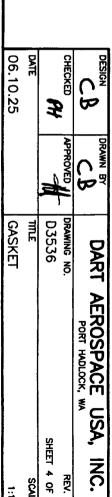
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT €
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

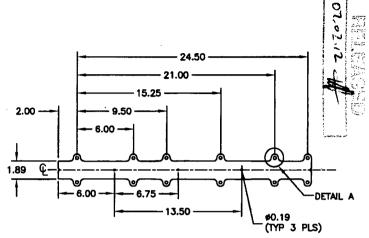


D3536-25 GASKET



SCALE 1:10

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D3536-33 GASKET

	22.50
2.00	19.00 ———————————————————————————————————
1.89 €	DETAIL A #0.19 (TYP 3 PLS)

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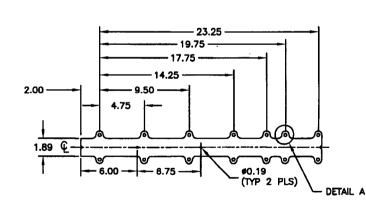
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PURPOSE

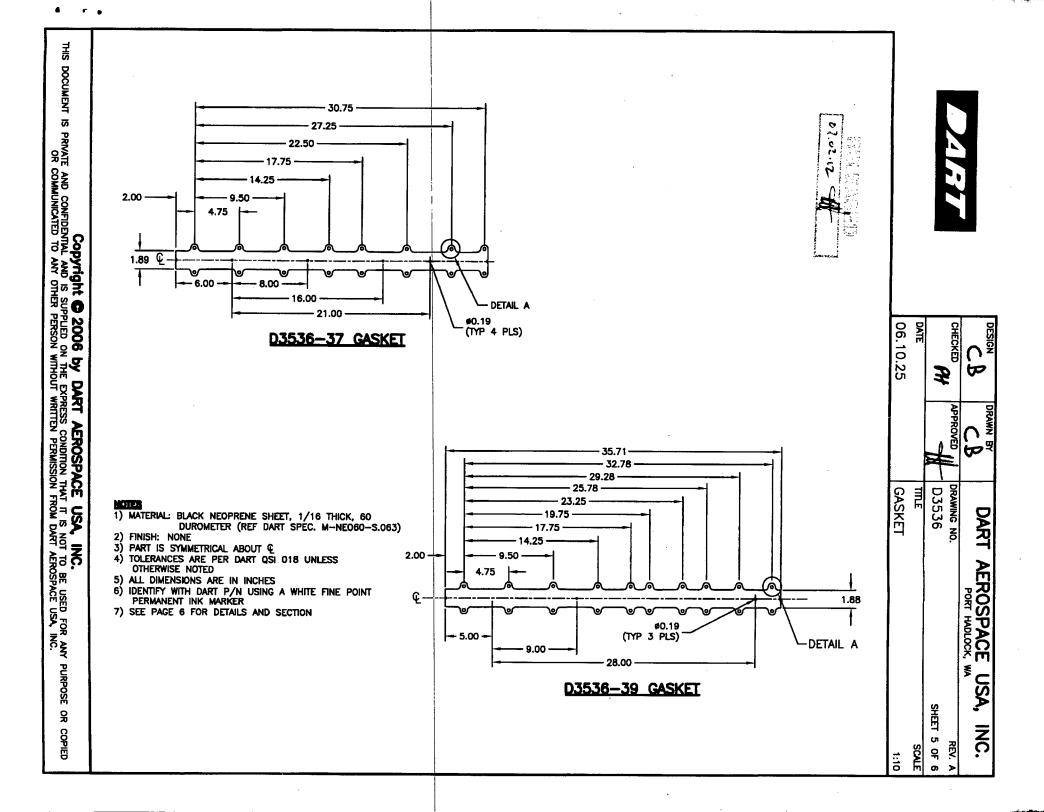
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

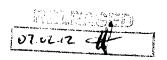


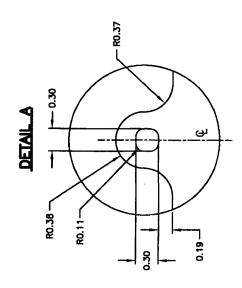
D3536-35 GASKET

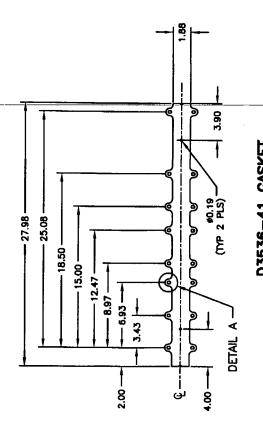




DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D3536	REV. A Sheet 6 of 6
DATE		TITLE	SCALE
06.10.25		GASKET	1:10







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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
DUROMETER (REF DART SPEC. M-NEO60-S.063) FINISH: NONE
PART IS SYMMETRICAL ABOUT €
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES
IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER 254

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